

Work Order ID 147204

147204

Page 1

Tuesday, June 07, 2016 11:26:45 AM

Item ID: D5343-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Hook
 Start Date: 6/7/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/22/2016 Req'd Qty: 20.00 ***20*** Customer:

Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5343	A								

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 32625
 Possible supplier: Victory Spring
 Manufacture as per Dwg
 Description: Long Hook

Material release note is required.

26.67

20

JUN 07 2016

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.07

20 Sp 16-6-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
				OTHER : ☐					

Tuesday, June 07, 2016 11:26:45 AM

Page 2

Stop ***NR2***

[illegible]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Tuesday, June 07, 2016 11:26:45 AM

Page 1

Work Order ID: 147204

147204

Parent Item: D5343-1

D5343-1

Parent Item Name: Long Hook

Start Date: 6/7/2016

Required Date: 6/22/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 16.06.06 NEW ISSUE DD VERFJLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5343-1P		Purchased		No			Each	0.0000		20			
D5343-1P									**				
Long Hook													

20X 50/6-6-20

DQA: _____ Date: _____

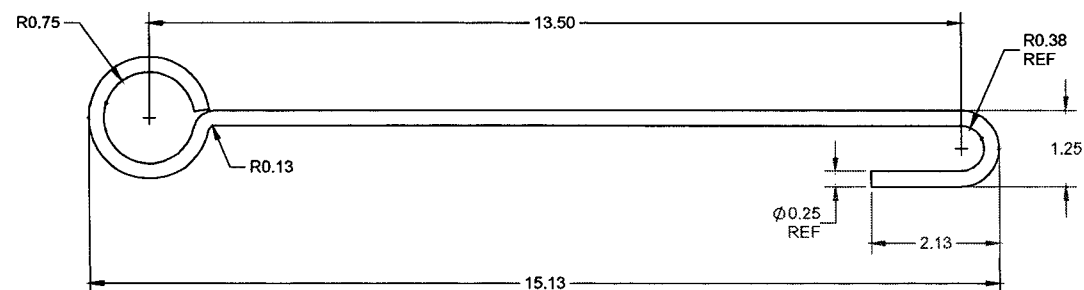


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									



D5343-1 LONG HOOK

NOTES:

- 1) MATERIAL: ANSI 304/316 SS ROUND BAR, $\phi 0.25"$
PER ASTM A276
REF DART SPEC M304R0.250
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.14) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.04 lbs

PRELIMINARY ISSUE

A		NEW ISSUE		VS	15.10.09
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	VS				
CHECKED	RF	DRAWING NO.		REV. A	
MFG. APPR.	JLM	D5343		SHEET 1 OF 1	
APPROVED		TITLE		SCALE	
DE APPR.		LONG HOOK		NTS	
DATE	15.10.09				
COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32625

Purchase Order Date 6/7/2016
PO Print Date 6/7/2016

Page Number 1 of 2

Order From :
VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

VC-VIC002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 07 2016

Contact Name
Vendor Phone 866 230 5312

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D5343-1P	Long Hook	6/15/2016 Yes 6/15/2016	FN	20.00 Each	\$14.85	\$297.00
	AS PER DWG D5343 REV. A B147204						
						Line Total:	\$297.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	6/15/2016 No 6/15/2016		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) A016 PERSONNEL QUALIFICATION A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS						

Note:

6/7/2016



#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
e + accounts@victoryspring.ca

PACKING SLIP

Packing Slip: 35297
Date: Jun 15, 2016
Order Ref: PO32625

Sold to:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship to:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Shipped By: FedEx Overnight

Shipped Quantity	Backorder Quantity	Unit	Item No.	Description	Price
20		Each	-	D5343-1P Long Hook <i>Spoke to JES</i>	14.85
Comment:					

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace	DATE: 6/15/2016																						
PART/DRAWING #: D5343-1P	PO # PO23625																						
SPRING DESCRIPTION: Long Hook	QUANTITY: 20																						
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03																							
PROPERTIES: <table> <thead> <tr> <th><u>Chemical</u></th> <th><u>Physical</u></th> </tr> </thead> <tbody> <tr> <td>Carbon: (C) 0.069</td> <td>Size: 0.250"</td> </tr> <tr> <td>Chromium: (Cr) 18.120</td> <td></td> </tr> <tr> <td>Copper: (Cu) 0.350</td> <td>Tensile PSI: 186,000</td> </tr> <tr> <td>Manganese: (Mn) 1.070</td> <td></td> </tr> <tr> <td>Molybdenum: (Mo) 0.230</td> <td></td> </tr> <tr> <td>Nickel: (Ni) 8.070</td> <td>Heat # 41824</td> </tr> <tr> <td>Nitrogen: (N) 0.080</td> <td></td> </tr> <tr> <td>Phosphorus: (P) 0.036</td> <td></td> </tr> <tr> <td>Silicon: (Si) 0.300</td> <td></td> </tr> <tr> <td>Sulphur: (S) 0.001</td> <td></td> </tr> </tbody> </table>		<u>Chemical</u>	<u>Physical</u>	Carbon: (C) 0.069	Size: 0.250"	Chromium: (Cr) 18.120		Copper: (Cu) 0.350	Tensile PSI: 186,000	Manganese: (Mn) 1.070		Molybdenum: (Mo) 0.230		Nickel: (Ni) 8.070	Heat # 41824	Nitrogen: (N) 0.080		Phosphorus: (P) 0.036		Silicon: (Si) 0.300		Sulphur: (S) 0.001	
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Sulphur: (S) 0.001																							
Mill Source: Sumiden Origin Country: USA																							

Certified by: Jeremy Burrowes - QA

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace	DATE: 6/15/2016
PART/DRAWING #: D5343-1P	PO # PO23625
DESCR: Long Hook	QUANTITY: 20

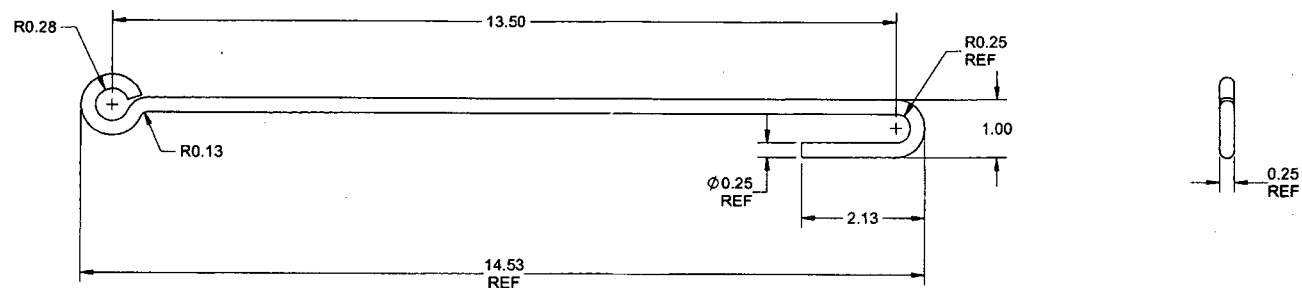
VICTORY SPRING CERTIFIES BY THIS DOCUMENT THAT ALL OPERATIONS ARE DONE ACCORDING TO
DRAWINGS AND SPECIFICATIONS

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	AISI 304/316 SS	AISI 302	
Material diameter	0.250"	0.250"	
Coil I.D.	R0.28"	R0.30"	
Hook OD	1.00"	1.04" - 1.06"	
Overall Length	14.53 ref	14.44" - 14.51"	
Hook Length	2.13"	2.13"	

Mill Certificate attached: Yes
Material Heat Number: 41824

Inspected by: Jeremy Burrowes - QA

Jeremy Burrowes



D5343-1 LONG HOOK

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR, $\phi 0.25$ ", FULL HARD
PER ASTM A276
REF DART SPEC M304R0.250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.7
- 7) WEIGHT: 0.26 lbs

RELEASED
2016-06-03
SCN16-593

APPROVED

A		NEW ISSUE		VS	15.10.09
REV.		DESCRIPTION		BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	VS				
CHECKED	AK	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5343			SHEET 1 OF 1
APPROVED	DW	TITLE	SCALE		
DE APPR.	DS	LONG HOOK	NTS		
DATE	15.10.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			